

Work Order ID 147943

Friday, June 17, 2016 7:58:17 AM

147943

Page 1

Item ID: D2565-109

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Strut

Start Date: 6/13/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/17/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MCS

Date:

JUN 20 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2565	Rev E								
100	Punch ends and deburr as per dwg NC BRAKE	0.00							
100									
Brake NC	Memo	0.04							
Brake NC	Punch as per Dwg D2565 using DT 8313								
110	Small Fab	0.00							
110									
Small Fab	Memo	0.11							
Small Fab	Deburr								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.01							
Quality Control									

OCT 13 2016

OCT 13 2016

DAS
38
9-88

OCT 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Page 2

Item ID: D2565-109 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut
Start Date: 6/13/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 6/17/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per OSI005 4.3-Steel <i>M 135418.</i> Memo START TIME: <i>9:15</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>9:45</i>	0.00 0.01				<i>4</i>	<i>φ 16-10-14.</i>	<i>DAS 34 9-89</i>	
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				<i>(4)</i>		<i>OCT 14 2016</i> <i>DAS 38 9-89</i>	
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>St354</i> Memo	0.00 0.01				<i>4</i>	<i>OCT 17 2016</i> <i>DAS 66 9-89</i>		

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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152				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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Required Date: 6/17/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160						DAS			
QC	Memo	0.07				21			
Quality Control						9-89			

DAS
21
9-89 OCT 1 R 2016

DAS
21
9-89 OCT 1 R 2016

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

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		OTHER : ☐			

Picklist Print

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Work Order ID: 147943

147943

Parent Item: D2565-109

D2565-109

Parent Item Name: Strut

Start Date: 6/13/2016

Required Date: 6/17/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: F02.04.16Added dwg Rev.C1NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	260.7070	1.0258	4.319158			

M304TR0 750W 049

FF OCT 13 2016

304 RD Tube .750 x .049W

Location	135373	1	Loc Qty	Loc Code	1.0798795
GA002	135709	3	255.1343002		3.2393685
	M132270		0.00001		
	M133131		0.0007242		
	M133509		14.210211		
	M133700		2.794323		
	M133914		5.98516		
	M134138		1.1364496		
	M134212		8.5144235		
	M134306		16.8053689		
	M134528		52.616579		
	M134604		49.23105		
	M134824		29.650527		
	M134993		74.189474		
MAT			5.5727347		
	M133400		5.5727347		

NOT Pulled

DQA: _____ Date: _____



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OTHER : _____					

